

Date: Tuesday, 28/10/2008 3:41:02 PM  
User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SLEEVE		
Job Number	: 43036			Part Number	: D37861		
Estimate Number	: 13330			Drawing Number	: D3786 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/10/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 15/11/2008		
Previous Run	: 40981			Qty:	30	Um:	Each
Written By	:						
Checked & Approved By	: JUD 08-10-29						
Comment	: Est Rev:A 08-05-20 new issue DD verified by:EC						
	: Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
Comment: Qty.: 0.1750 f(s)/Unit Total : 5.2511 f(s) 6061T6 TUBE batch: M107854		
		5.5ft
2.0	DOOSAN LATHE	DOOSAN LATHE
Comment: DOOSAN LATHE		
		08/11/20
1- Turn as per Folio FA747 Rev: <u>N/A</u> & Dwg D3786 Rev: <u>A</u>		
2-Deburr per dwg D3786		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
		08/11/20
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
		08/11/20
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
		08/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 43036

Part Number: D37861

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



W 08 11 22



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: P118

C. Dawson (30)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	W3030
Description: Sleeve	Part Number:	D3786-1
Inspection Dwg: D3786	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>SH</u>	Audited by:	<u>RD</u>	Prototype Approval:	N/A
Date:	<u>08/11/2011</u>	Date:	<u>08/11/2011</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.25	New Issue	KJ/DD	

8

7

6

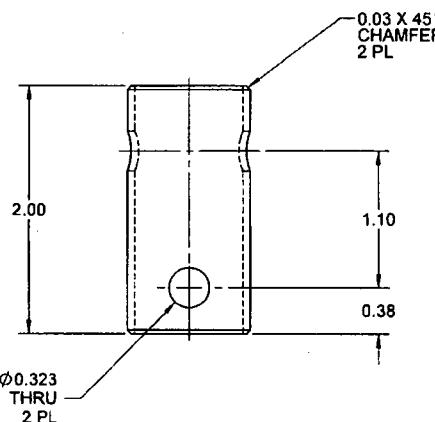
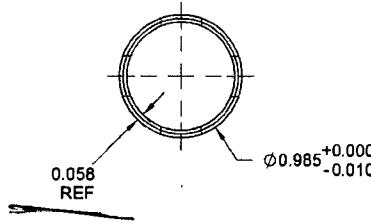
5

4

3

2

1



**RELEASED**  
08/26/16 (10)

### D3786-1 SLEEVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. R3830

#### NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 0.03 lbs

A	REV.	NEW ISSUE	HS	08.06.04
		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE		08.06.04	SCALE	
D3786		SHEET 1 OF 1		
TITLE		SLEEVE		NTS
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